



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D505-1049-011
Job Sheet 183506



Part No: D505-1049-011

Job Qty: 1 ea

Part Name: 505 Bearpaws with wearplates



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/19/18

Job Tracking No:

Due Date: 10/17/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: Dwg. D505-1049 Rev.B IPP Rev.A New issue JFS 17/11/01 Verified by:DD IPP Rev.B Updated Bom per dwg.
RevB JFS 18/03/01 Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/17/18	10/17/18	0.00	0.00	Start Up Stores/Pkg-2		OCT 09 2018
160	Packaging	1 pcs	10/17/18	10/17/18	0.00	0.00	Packaging1		OCT 09 2018
170	QC	1 pcs	10/17/18	10/17/18	0.00	0.00	QC4		OCT 09 2018
175	DC	1 pcs	10/17/18	10/17/18	0.00	0.00	DC		OCT 09 2018
180	Packaging	1 pcs	10/17/18	10/17/18	0.00	0.00	Packaging3		OCT 09 2018
190	QC21-FG	1 Ea	10/17/18	10/17/18	0.00	0.00	QC21		OCT 09 2018

Part Op 175 - Photocopy bluefile and create labels per PPP D505-1049-011 CHG001
Descriptions: 180 - Identify and pack for shipping as per PPP d505-1049-011 LOCATION:

OCT 09 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2274	Radius Block	8 Ea (8 ea)	90-Start up Operation	5097635
D2529	Washer	16 Ea (16 ea)	90-Start up Operation	5033981
D5560-1	Bearpaw	2 Ea (2 ea)	90-Start up Operation	5105257
D5566-1	Clamp	4 Ea (4 ea)	90-Start up Operation	5059879
D5567-1	Cushion	4 Ea (4 ea)	90-Start up Operation	5060110
MS21042L4	Nut	8 Ea (8 ea)	90-Start up Operation	5094597
MS21083N4	Nut	8 Ea (8 ea)	90-Start up Operation	5062621
NAS1149D0463J	Washer	8 Ea (8 ea)	90-Start up Operation	5089299
NAS1801-4-30	Bolt	8 pcs (8 ea)	90-Start up Operation	5107794
QS200-M40S	Clamp	2 pcs (2 ea)	90-Start up Operation	5107712

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2274	8	210	0
	D2529	16	1,197	0
	D5560-1	2	12	0
	D5566-1	4	62	0
	D5567-1	4	4	0
	MS21042L4	8	4,070	0
	MS21083N4	8	244	0
	NAS1149D0463J	8	7,164	0
	NAS1801-4-30	8	61	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																	
Date : _____	Step #: _____	MRB (QSI042) Approval _____																																																																																																																																	
Description Work Order Deviation		10/9/2018 [Dart Hawkesbury] Prod... Special Comments : Container No : S116526 Dart Hawkesbury https://www.plexonline.com/4C6EAA9... 2/2 10/9/2018 [Dart Hawkesbury] Prod... D505-1049-011 505 Bearpaws with wearplates Active Operation : 90-Start up Operation Next Op : 160-Packaging Status : Allocated Change Number : Printed : 10/9/18 8:28 AM Jocelyne Joly https://www.plexonline.com/4C6EAA9... 1/2																																																																																																																																	
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Environment</td><td style="width:5%;">☐</td><td style="width:15%;">No Re-verification</td><td style="width:5%;">☐</td><td style="width:15%;">Pressure/Forced</td><td style="width:5%;">☐</td><td style="width:15%;">Positioned Wrong</td><td style="width:5%;">☐</td></tr> <tr> <td>Design</td><td>☐</td><td>Operator</td><td>☐</td><td>Bending</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr> <tr> <td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td><td>Centre Not Concentric</td><td>☐</td><td>Over/Under tolerance</td><td>☐</td></tr> <tr> <td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td><td>Cracks</td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr> <tr> <td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr> <tr> <td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td><td>Cuffs</td><td>☐</td><td>Part Moved</td><td>☐</td></tr> <tr> <td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td><td>Crushing</td><td>☐</td><td>Drawing</td><td>☐</td></tr> <tr> <td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td><td>Heat Treat</td><td>☐</td><td>Finish</td><td>☐</td></tr> <tr> <td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td><td>Wave/Twist in Tube</td><td>☐</td><td>Misread</td><td>☐</td></tr> <tr> <td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td><td>Marks/Chatter</td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr> <tr> <td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td><td></td><td>☐</td><td></td><td></td></tr> <tr> <td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td><td></td><td>☐</td><td></td><td></td></tr> </table>		Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Positioned Wrong	☐	Design	☐	Operator	☐	Bending	☐	Outside Dimensions	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	Over/Under tolerance	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Part Incorrect	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Part Lost/Missing	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Part Moved	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Drawing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Finish	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Misread	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐		☐			Misidentified	☐	Past Due	☐		☐			<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">☐</td><td style="width:15%;">Inspection Incomplete/Unqualified</td><td style="width:15%;">☐</td><td style="width:15%;">Wrong Stock Pulled</td><td style="width:15%;">☐</td></tr> <tr> <td>☐</td><td>Contamination</td><td>☐</td><td>Out of Sequence</td><td>☐</td></tr> <tr> <td>☐</td><td>Countersink</td><td>☐</td><td>Off-set</td><td>☐</td></tr> <tr> <td>☐</td><td>Cut Too Short</td><td>☐</td><td>Mislabeled</td><td>☐</td></tr> <tr> <td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td><td>Fit/Function</td><td>☐</td></tr> <tr> <td>☐</td><td>Drill Holes</td><td>☐</td><td>Misaligned/off center</td><td>☐</td></tr> </table>				☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	☐	Contamination	☐	Out of Sequence	☐	☐	Countersink	☐	Off-set	☐	☐	Cut Too Short	☐	Mislabeled	☐	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	☐	Drill Holes	☐	Misaligned/off center	☐
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Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER : ☐							

4 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D505-1049-011 <i>Bearpaw Installation</i>	11.1 lb 5.03 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	191.6 in 4.87 m	2127 in-lb 24.5 m-kg
D505-1049-013 <i>Bearpaw Installation with Wearplates</i>	14.5 lb 6.58 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	191.4 in 4.86 m	2775 in-lb 32.0 m-kg
D505-1049-041 <i>Wearplate Kit</i>	3.4 lb 1.54 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	190.8 in 4.85 m	649 in-lb 7.5 m-kg

5 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D505-1049-011	BEARPAW INSTALLATION
	X		D505-1049-013	BEARPAW INSTALLATION WITH WEARPLATES
		X	D505-1049-041	WEARPLATE KIT
8	8		D2274	Radius Block
16	16	8	D2529	Washer
4	4		D5566-1	Clamp
4	4		D5567-1	Cushion
	2	2	D5559-041	Wearplate
2	2		D5560-1	Bearpaw
	8	8	AN4-7A	Bolt
8	8		NAS1801-4-30	Bolt
8	8		NAS1149D0463J	Washer
8	16	8	MS21042L4	Nut (or MS21042-4)
8	8		MS21083N4	Nut
2	2		QS200-M40S	Hose Clamp